Work Order ID 74537 - 2. SPLIT

Tuesday, October 04, 2011 8:21:17 AM

Item ID: D3121-241 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bearing Assembly

Start Date: 9/30/2011 **Start Qty:** 20.00 ~~50~~ 116

Required Date: 10/14/2011 **Req'd Qty:** ~~20.00~~

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** M L J **Date:** 11/10/04 **Tooling:** **Date:** **Run Start**

QC: **Date:** **SPC (Y/N):** **Date:** **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3121	Rev E								
100	Hardinge CNC LATHE SMALL	0.00				50	ϕ		
Hardinge									
Hardinge CNC Lathe Small	**Memo** 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr	0.00							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				50	ϕ		
QC									
Quality Control	**Memo**	0.00							
120	QC8- Inspect parts - second check	0.00				50	ϕ		
QC									
Quality Control	**Memo**	0.00							

Work Order ID 74537

Tuesday, October 04, 2011 8:21:17 AM

Item ID: D3121-241 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Bearing Assembly

Start Date: 9/30/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
Small Fab	**Memo**	0.00							
Small Fab	1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location ST-235A .	0.00							
Packaging	**Memo**	0.00							
Packaging									

MF 11-10-07

Sulola

(11x) SP 11-10-11.

Work Order ID 74537

Tuesday, October 04, 2011 8:21:17 AM

Item ID: D3121-241 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Bearing Assembly

Start Date: 9/30/2011 **Start Qty:** 20.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 20.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:** **Stop**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/10/11 MF

11-10-11

Picklist Print

Tuesday, October 04, 2011 8:21:24 AM

Work Order ID: 74537

Parent Item: D3121-241

Parent Item Name: Bearing Assembly

Start Date: 9/30/2011 **Required Date:** 10/14/2011

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP Rev:A 04.02.18 New issue KJ/DS
IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	34.6090	0.052	1.04			
Delrin Round Bar 1"													

Location	Loc Qty	Loc Code
MAT055	34.609	
117985	0.407	
✓ 118257	19.202	
✓ 118392	15	

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-23		Manufactured	No			130	Each	10.0000	1	20			
Bearing													

Location	Loc Qty	Loc Code
ST235	10	
66734	10	

DART AEROSPACE LTD	Work Order:	74537
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.315	+/-0.010	0.3175	✓		CNC 02	
Ø1.000	+/-0.010	Ø1.000	✓		RQ 06	
Ø0.838	+/-0.002	Ø0.8385	✓			
R0.063	+/-0.010	R.0.063	✓			
R0.010	+/-0.010	R.0.010	✓			
0.230	+/-0.001	0.229	✓			
Ø0.865	+/-0.001	Ø0.8655	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/10/07	Date:	11/10/07	Date:	N/A

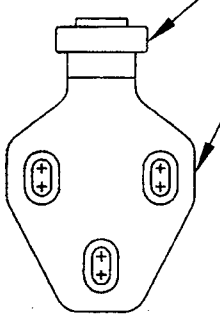
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	

DART

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DATE 07.11.07		TITLE BRACKET ASSEMBLY SCALE 1:2

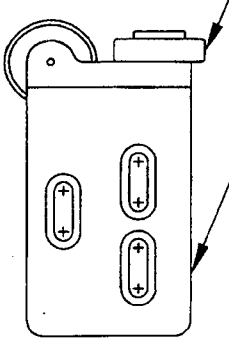
A	02.04.15	NEW ISSUE
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD −141/−143/−144/−145/−146
C	04.02.17	ADD CLEARANCE; USE −241 BEARING
D	06.05.17	D3121−25 CAP WAS 1.024, NOW 1.000
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)

RELEASED
07.11.07 WD

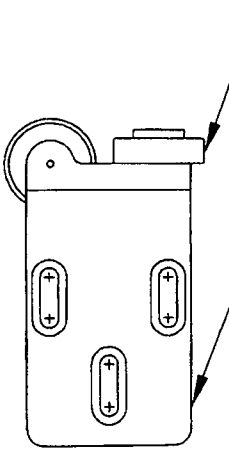


D3121−041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−33)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74537 M.L.S
11/10/04



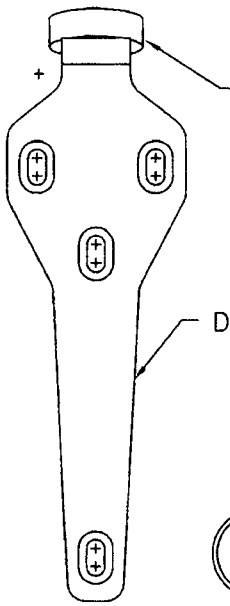
D3121−043 (SHOWN) / D3121−044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−37/−38)



D3121−045 (SHOWN) / D3121−046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30−23000−35/−36)

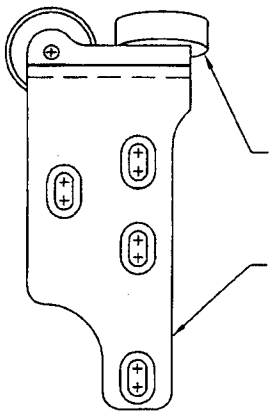
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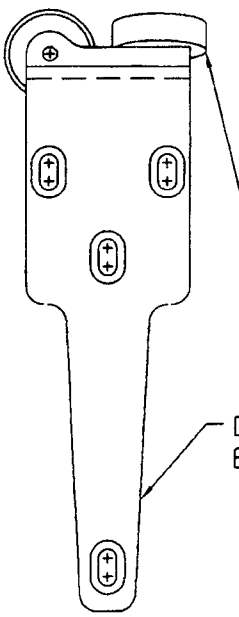


D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)

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D3121-143 (SHOWN) / D3121-144 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



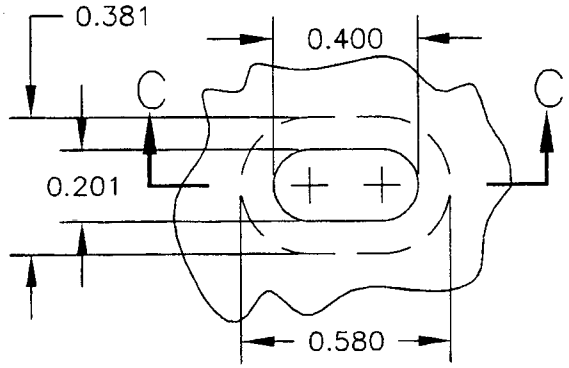
D3121-145 (SHOWN) / D3121-146 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

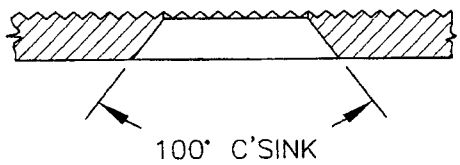
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DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

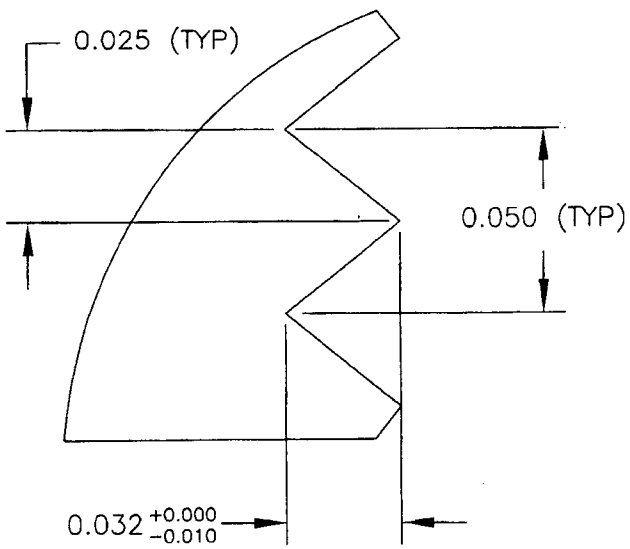




SECTION C–C

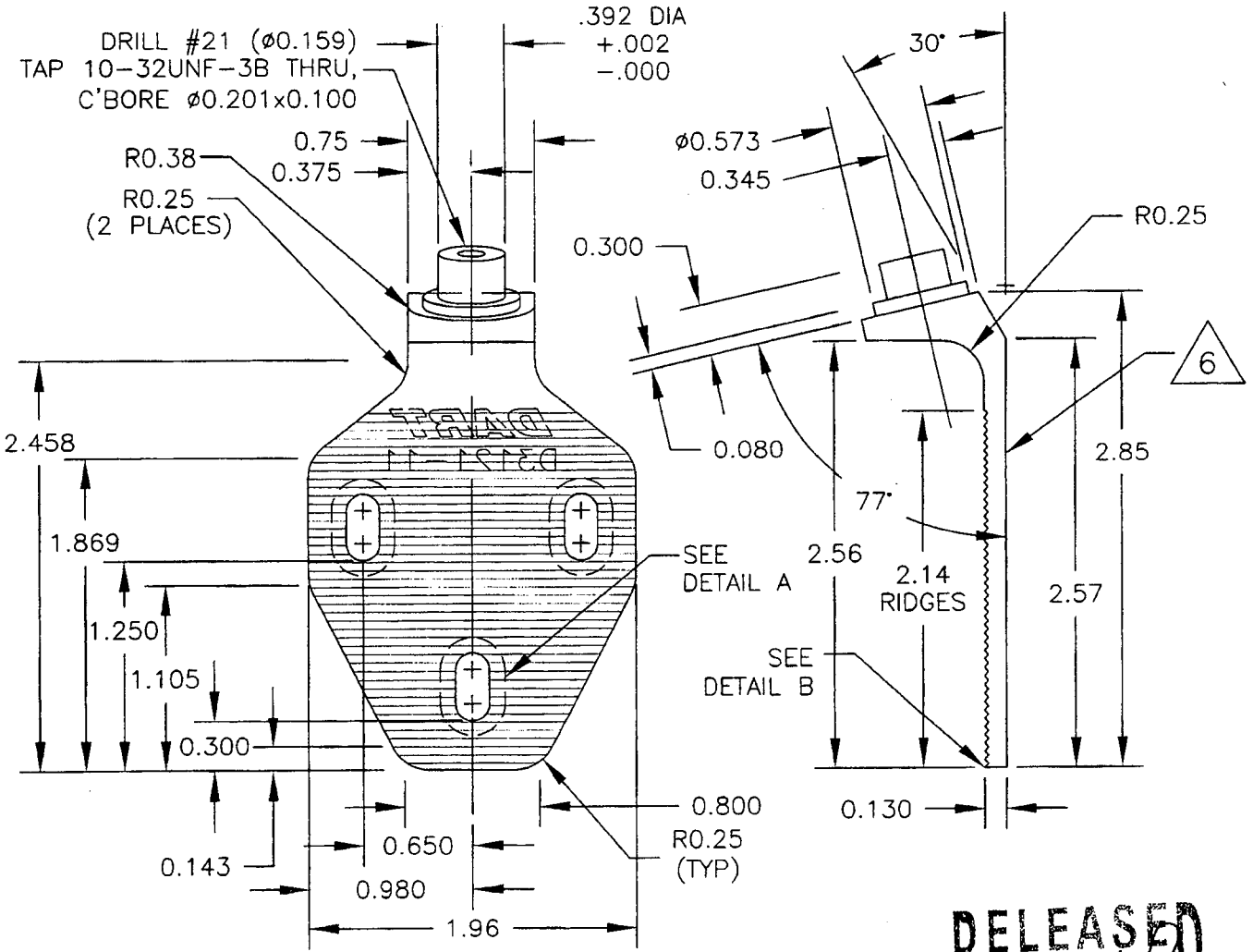
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DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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D3121-11 BRACKET

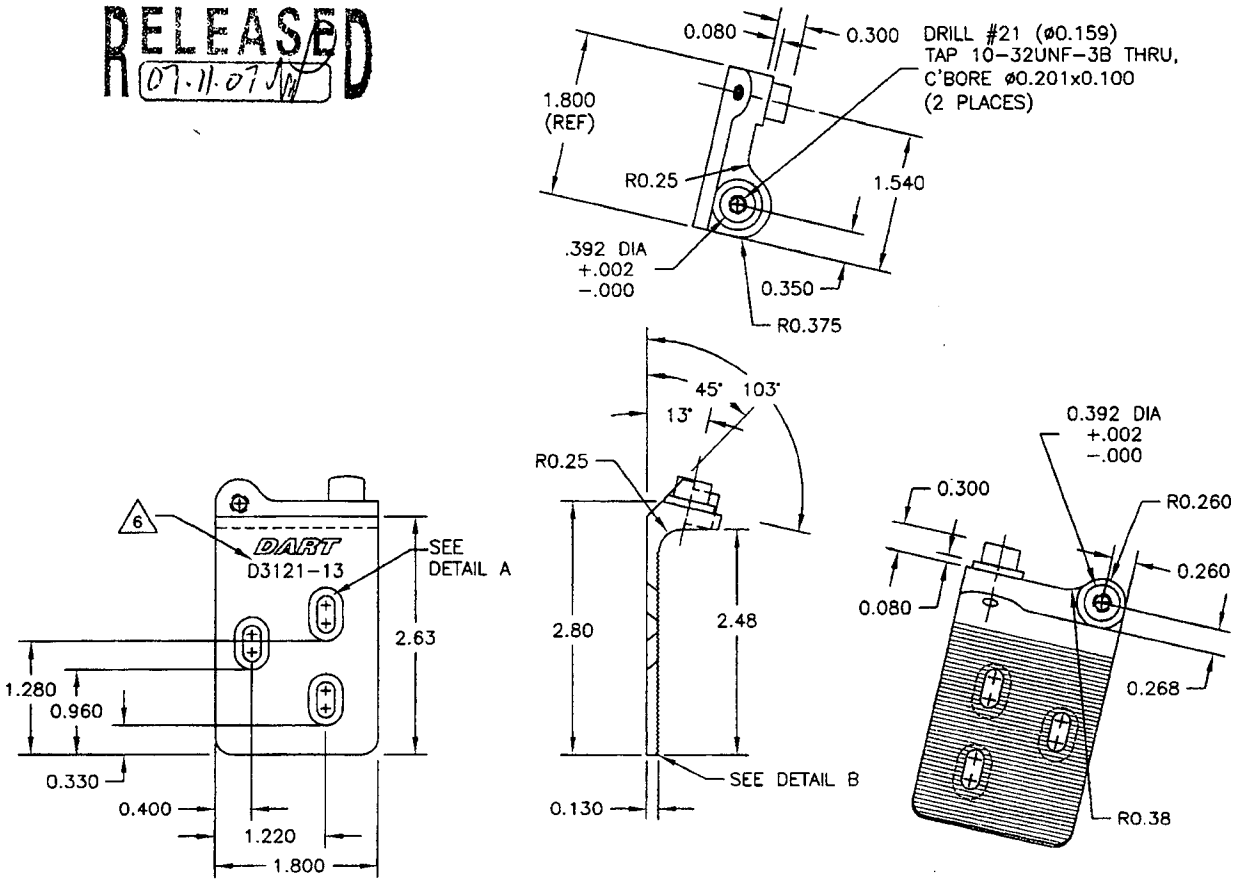
1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

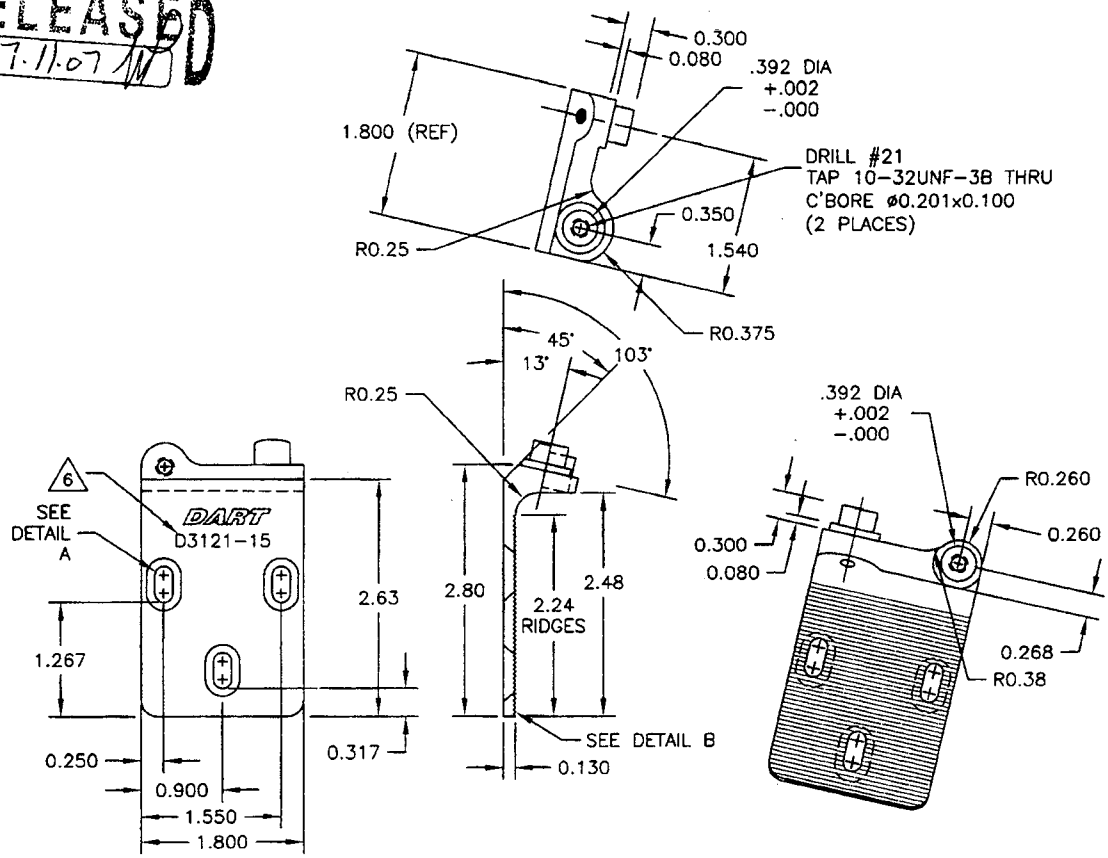
1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N & LOGO AS SHOWN
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D3121−15 BRACKET (SHOWN)
D3121−16 BRACKET (OPPOSITE)

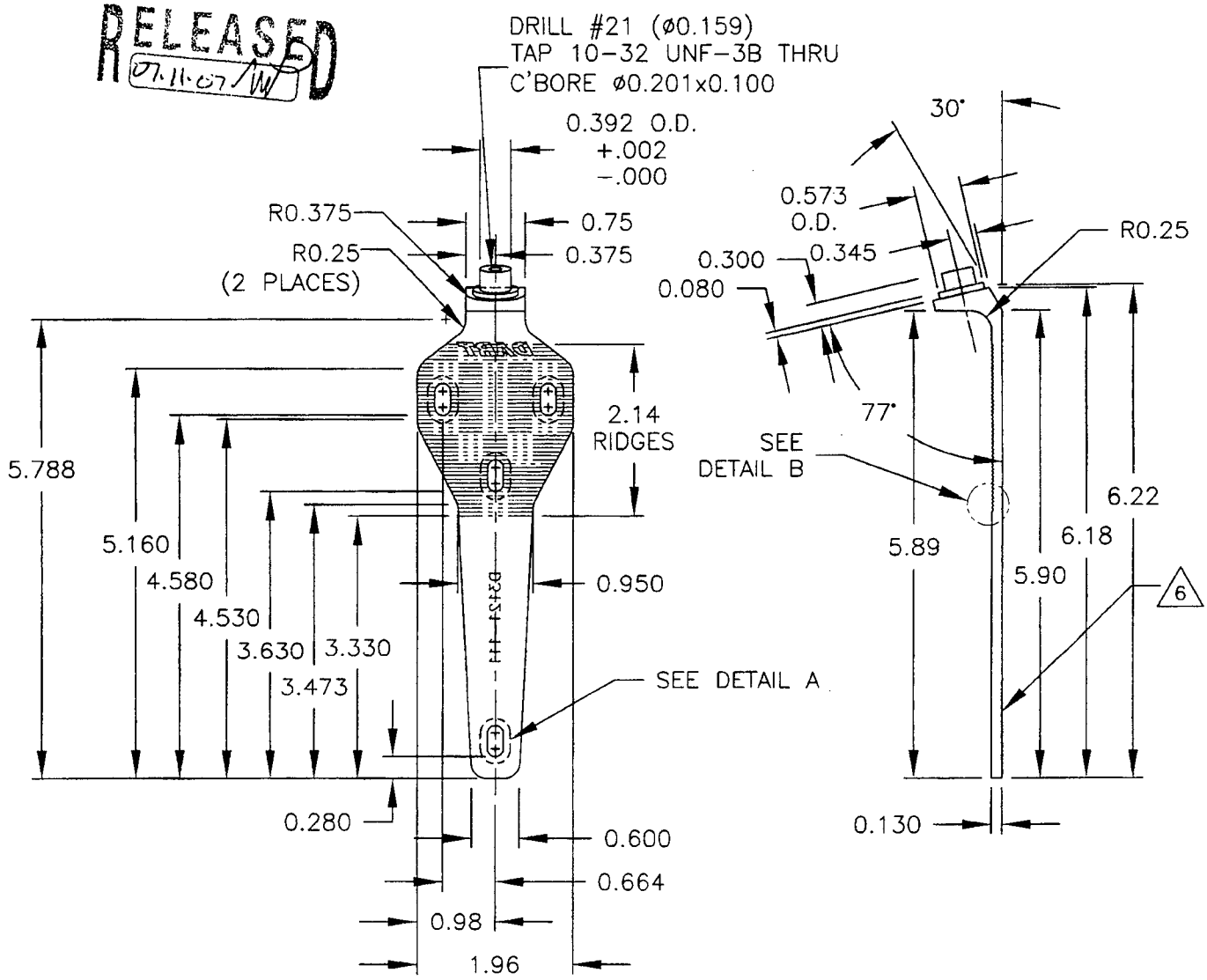
1) MATERIAL: 17−4 SS PER AMS 5604/5643 (REF DART SPEC. M17−4−B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.015
5) ENGRAVE DART P/N AND LOGO AS SHOWN
6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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D3121-111 BRACKET

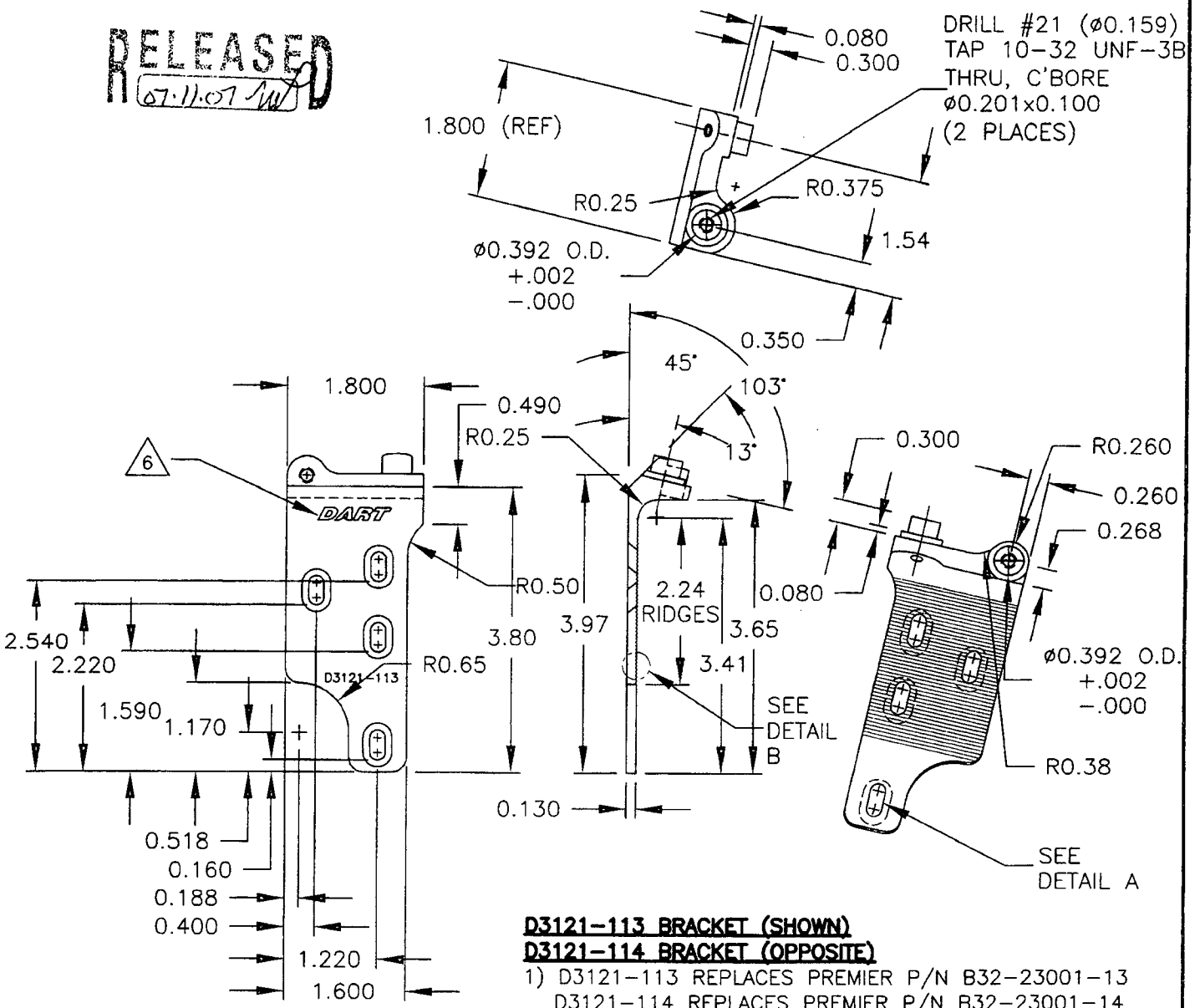
1) REPLACES PREMIER P/N B32-23001-11
2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE = 150 ksi
 MIN YIELD TENSILE = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
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D3121-113 BRACKET (SHOWN)
D3121-114 BRACKET (OPPOSITE)

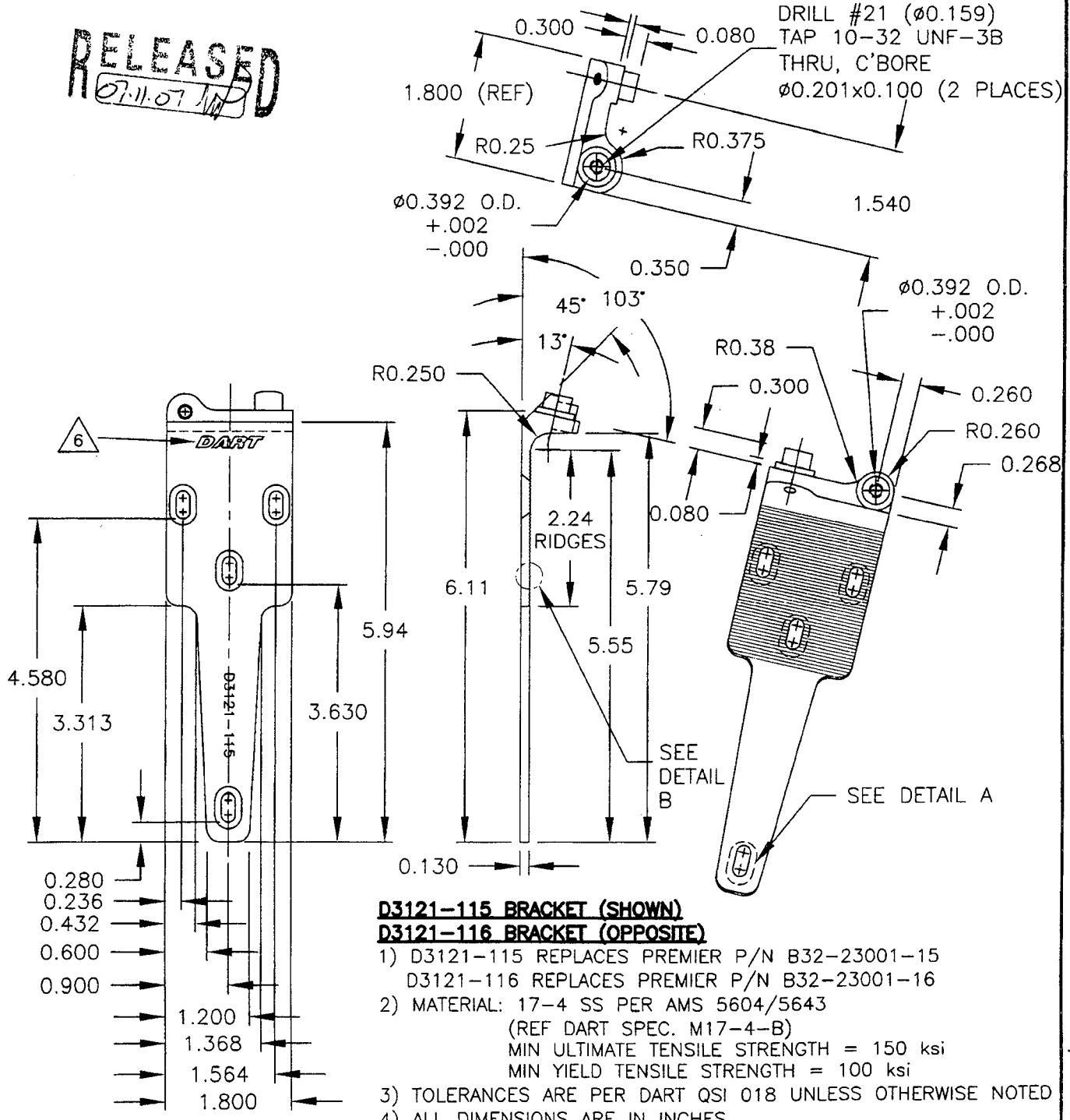
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 D3121-114 REPLACES PREMIER P/N B32-23001-14
2) MATERIAL: 17-4 SS PER AMS 5604/5643
 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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174534

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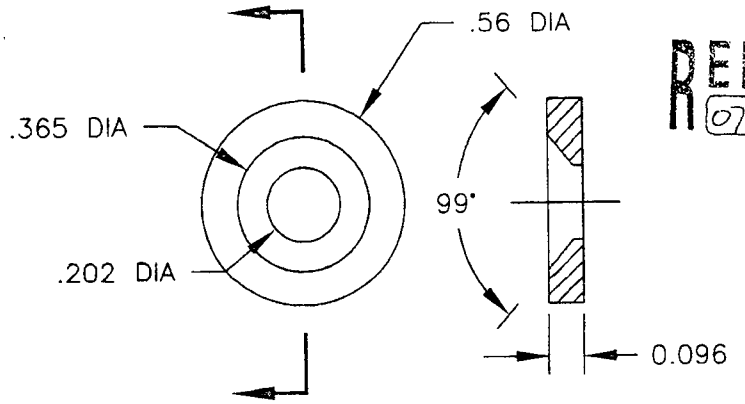
D3121-115 BRACKET (SHOWN)
D3121-116 BRACKET (OPPOSITE)

1) D3121-115 REPLACES PREMIER P/N B32-23001-15
 D3121-116 REPLACES PREMIER P/N B32-23001-16
2) MATERIAL: 17-4 SS PER AMS 5604/5643
 (REF DART SPEC. M17-4-B)
 MIN ULTIMATE TENSILE STRENGTH = 150 ksi
 MIN YIELD TENSILE STRENGTH = 100 ksi
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015
6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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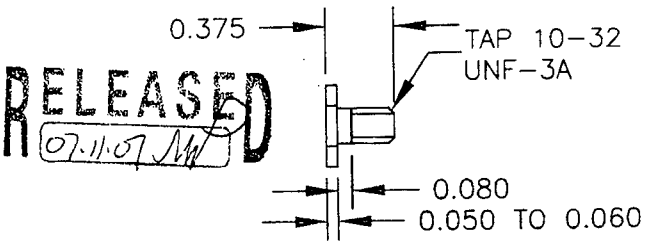
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

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07.11.07



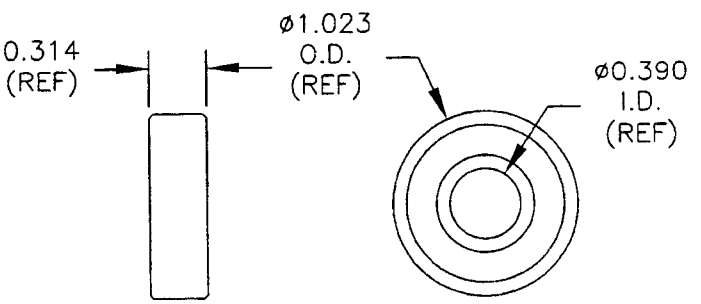
D3121-17 WASHER (SCALE 2:1)

1) REPLACES PREMIER P/N B32-23001-17
2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



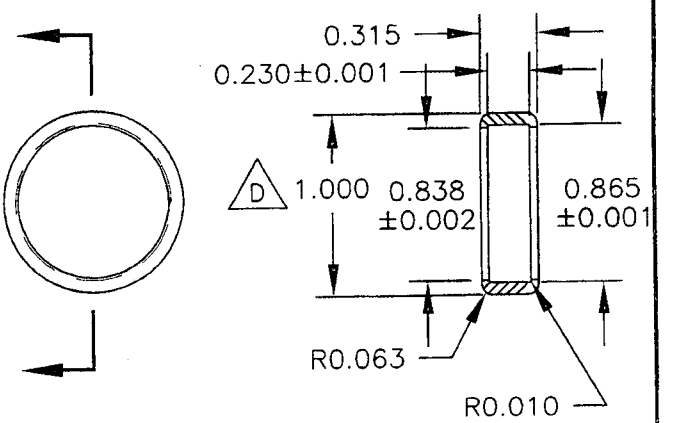
D3121-21 BOLT (SCALE 1:1)

1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.015



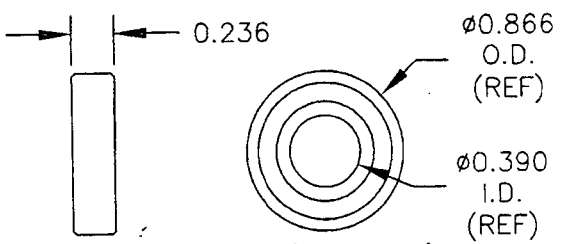
D3121-19 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
2) ALL DIMENSIONS ARE IN INCHES



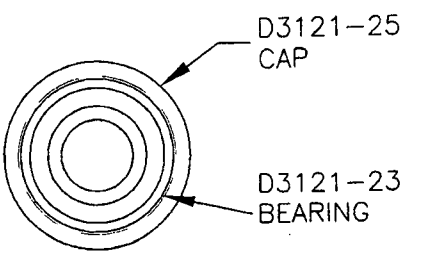
D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
2) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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